

**Work Order ID 53202**

October 26, 2009 12:41:54 PM



Page 1

Item ID: D2512

Accept



Setup Start



Revision ID: E

Stop



Item Name: Basket Lid 205/350

Start Date: 26/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 1.00



Customer:

**Reference:**Approvals: Process Plan: *RL*Date: *09-10-26*

Tooling:

Date:

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2512	Rev E

100 Weld per dwg A/R S.S. rod Batch: *M109213* 0.00  
Large Fab

Large Fab Memo 0.00

Large Fab 1-Cut 3/4" x 3/4" square tubing as per Dwg D2512

2-Cut (4) D2236 From D3166-3

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305

4-Weld as per Dwg D2512 using Welding Jig DT 9436

Deburr as required

\*\*\*INSTALL D2012-II 7 CLEVIS ONLY ON D130-701-041\*\*\*

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

QC Memo 0.00

Quality Control

*RL 09 10 30**10 09.11.02*

**Work Order ID 53202**

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Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC6- Inspect dimensions to drawing

0.00

→ S orluluz



QC

Memo

0.00



Quality Control

130

\* Processed per WIP AS/MT  
White Gloss(Ref.4.3.5.1) per QSI005 4.3-Alum

0.00

M 11/11/09



Powdercoat

Powder Coating

Memo

0.00

X O O

—1- Plug holes in D2581 and in D2327-1 bushing prior to Powdercoat

1ST COAT:  
 START TIME: 2:00PM  
 OVEN TEMPERATURE: 400°F  
 FINISH TIME: 2:30PM

2ND COAT:  
 START TIME: 2:30PM  
 OVEN TEMPERATURE: 400°F  
 FINISH TIME: 3:00PM

**Work Order ID 53202**

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Stop



Item Name: Basket Lid 205/350

Start Date: 26/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140



HandFinishing

0.00

HandFinish

Hand Finishing

Memo *M 112437 BLACK. 0.00*

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

Batch: *1112106**BR 09-11-4**D.*

150



QC3- Inspect Part Finish

0.00

QC

Quality Control

Memo

0.00

*MD 0911104**X1*

160

Identify as per dwg & Stock Location: *PNP*

0.00

Packaging

Packaging

Memo

0.00

*B 52036 C 9111080*

**Work Order ID 53202**

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Item ID: D2512

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Item Name: Basket Lid 205/350

Start Date: 26/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/04 AJ

PL 0911-5

# Picklist Print

Page 1

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4

Work Order ID: 53202



Parent Item: D2512RevE



Parent Item Name: Basket Lid 205/350

Start Date: 26/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2012-117RevC		Manufactured	No			100	Each	24.0000	2.0000			

Clevis

**Warehouse****Location**

## Main Warehouse

ST	24
31101	2
52498	22

\*\*\*ONLY APPLICABLE ON D130701-H7\*\*\*

D2232-1RevC



Manufactured No

100 Each 26.0000 2.0000



Basket Hinge

**Warehouse****Location**

## Main Warehouse

ST	2
48230	2

## Main Warehouse

WA	24
50896 ✓	4
51105	20

**Picklist Print**

Page 2

October 26, 2009 12:41:59 PM

Work Order ID: 53202



Parent Item: D2512RevE



Parent Item Name: Basket Lid 205/350

Start Date: 26/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2327-1RevD



Manufactured

No

100

Each

41.0000

2.0000



Spacer Bushing

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST

41

51331 ✓

16

52832

25

D2506RevF



Manufactured

No

100

Each

13.0000

1.0000



Label Plate

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST

1

44275

1

Main Warehouse

WA

12

51303 ✓

2

52834

10

**Picklist Print**

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October 26, 2009 12:41:59 PM

Work Order ID: 53202



Parent Item: D2512RevE



Parent Item Name: Basket Lid 205/350

Start Date: 26/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Item ID/ Item ID	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2581RevA1			Manufactured	No			100	Each	66.0000	2.0000			

Mounting Bracket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

## Main Warehouse

ST	13	
46086	2	
48428	1	
51120	10	

## Main Warehouse

WA	53	
50872	4	
51745 ✓	49	

D3166-3RevA1

Manufactured

No

100

Each

11.6210 1.0000



② GLC 09.10.27

SAD 09-10-27

Basket Hoop

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

## Main Warehouse

WA	11.621	
50033	0.0527	
50618	0.5683	
51249	5	
52058	6	

**Picklist Print**

Page 4

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Work Order ID: 53202



Parent Item: D2512RevE



Parent Item Name: Basket Lid 205/350

Start Date: 26/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304EX0.75-16F		Purchased	No			100	sf	476.5700	18.9474		SAD	09-10-28

Expanded Metal Flat SS

	<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	Main Warehouse		
	MAT	476.5700065	
	110134	3.4	
	111630	5.85	2.00
	111956	0.000017	
	112147	8.29428947	
	112311	28.9205	
	112707	110.1052	16.9474
	112949	320	

M304TS0.750W.065

Purchased	No	100	f	460.8319	45.8741		SAD	09-10-27
-----------	----	-----	---	----------	---------	--	-----	----------

304 SQ Tube .75x.75x.065W

	<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	Main Warehouse		
	WA	460.8318947	
	112398	460.831895	45.8741

Scrap End Bar B# 112398 Qty 0.7 sq ft

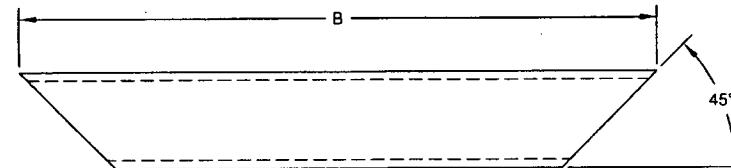
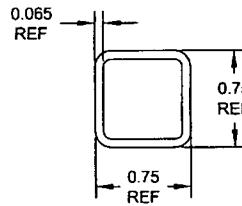
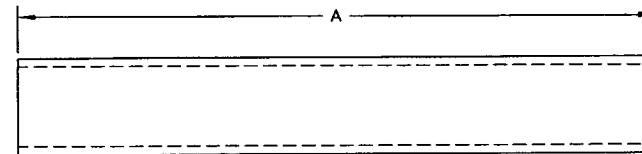
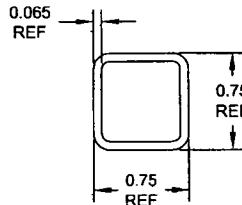
## PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2		25.50	RIB
D2512-3	2		95.30	RIB
D2512-5	6	30.84		RIB
D2512-7	3	30.63		RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 53202

*PL09-10-26*

**RELEASED**  
*08-08-21/14*



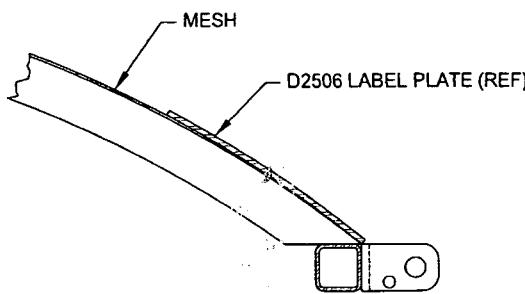
**E**

**D2512-1/3-5/-7 NOTES:**

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING  
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

E		INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3 ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D		CHANGE HINGE	CP	01.04.19
C		REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP DEO 9074	DS	99.07.06
B		ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A		NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION			BY DATE
DESIGN		BW	<b>DART AEROSPACE LTD</b>	
DRAWN		AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED			DRAWING NO.	REV. E
MFG. APPR.			D2512	SHEET 1 OF 4
APPROVED			TITLE	SCALE
DE APPR.			BASKET LID ASSEMBLY (350/212) NTS	
DATE	08.06.17			COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS TO BE KEPT IN A SECURE CONDITION, THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD

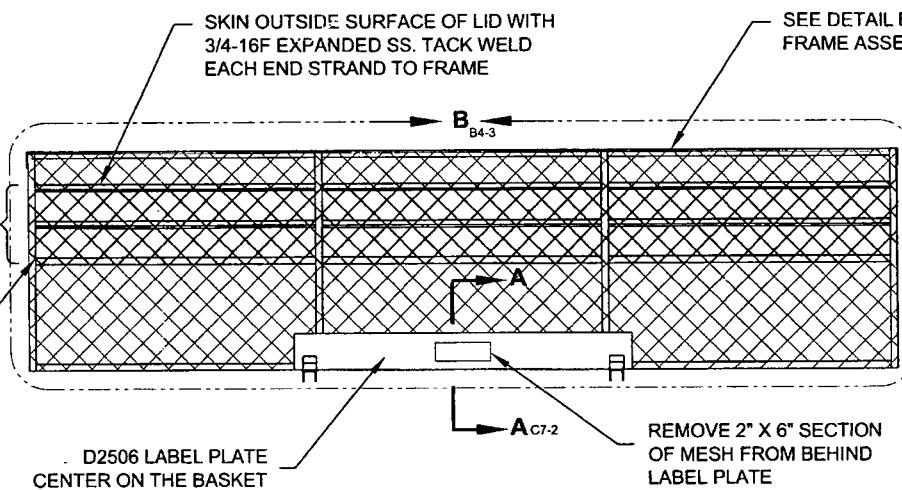
8 7 6 5 4 3 2 1



**SECTION A-A<sub>B3-2</sub>**  
(ROTATED 90° CCW)

FINISH THIS SECTION ALONG  
ENTIRE LENGTH PER NOTE 3  
AFTER POWDER COAT.

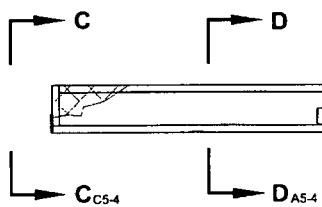
TACK WELD MESH TO FRAME  
AT EVERY AVAILABLE LOCATION  
IN AREA TO BE ANTI-SKIDDED



E

**D2512 BASKET LID ASSEMBLY NOTES:**

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS  
REF DART SPEC M304EX0.75-16F
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE  
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004



RELEASED  
08.06.17

DESIGN	BW	DART AEROSPACE LTD
DRAWN	AJS	HAWKSLEY, ONTARIO, CANADA
CHECKED	S	DRAWING NO. REV. E
MFG. APPR.	AM	D2512 SHEET 2 OF 4
APPROVED	AM	TITLE SCALE
DE APPR.	AM	BASKET LID ASSEMBLY (350/212) NTS
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8 7 6 5 4 3 2 1

8

7

6

5

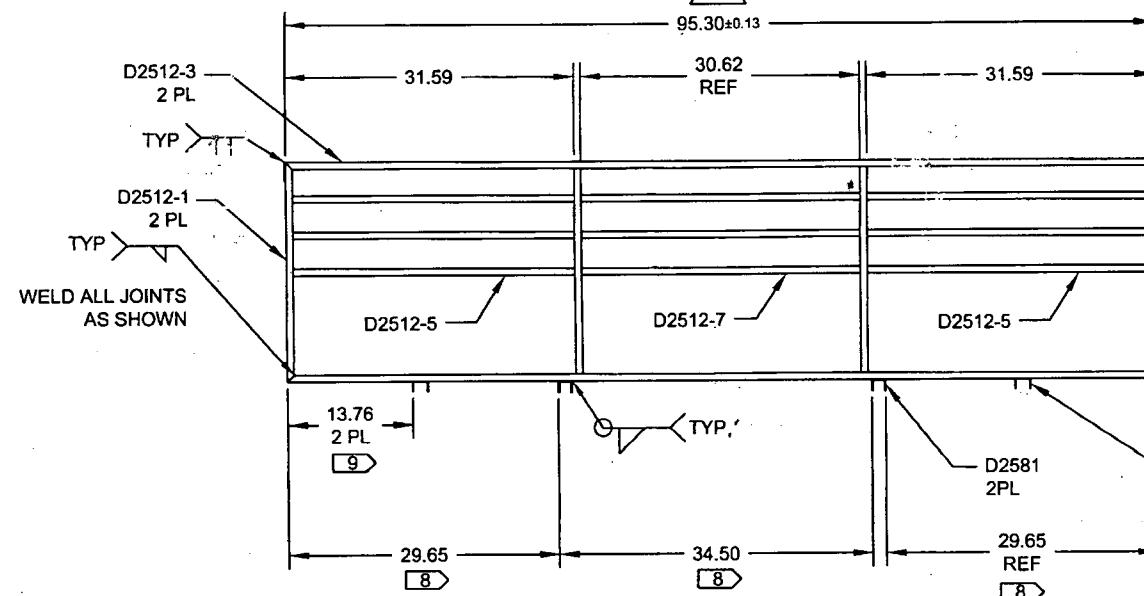
4

3

2

1

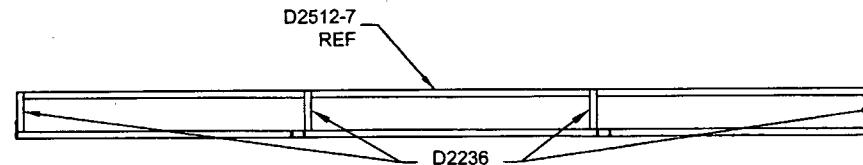
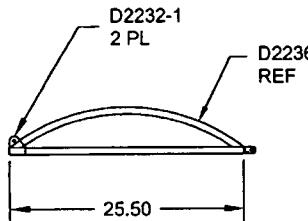
E



SHOP  
RETURN  
ENGINEER  
UNCONTROLLED  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORIGINATED  
NO. 53202

### DETAIL B C3-2

FRAMEWORK ONLY SHOWN FOR CLARITY



RELEASED  
08-06-21/14

### NOTES:

MATERIAL: NONE

FINISH: NONE

TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

UNITS: INCHES UNLESS OTHERWISE NOTED

BREAK SHARP EDGES: N/A

IDENTIFICATION: NONE

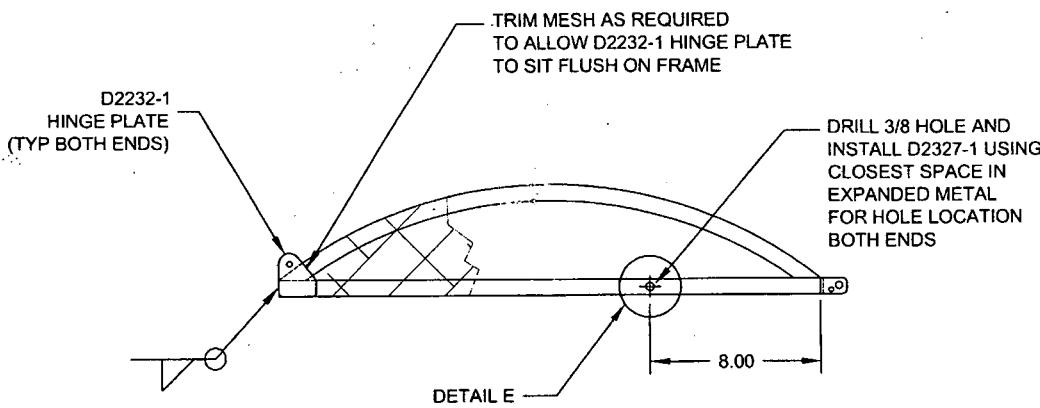
WEIGHT: N/A

LOCATE IN CONJUNCTION WITH ADJACENT D2581 ON BASKET BASE ASSEMBLY

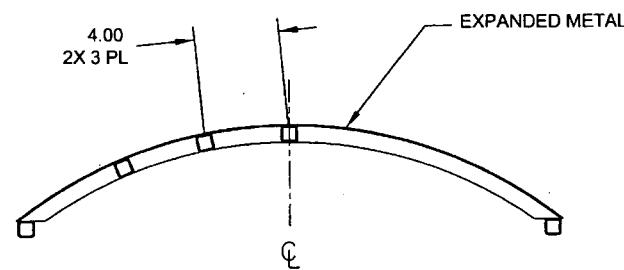
FOR D130-701-041 ONLY

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
		D2512	SHEET 3 OF 4
MFG. APPR.			
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
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8 7 6 5 4 3 2 1

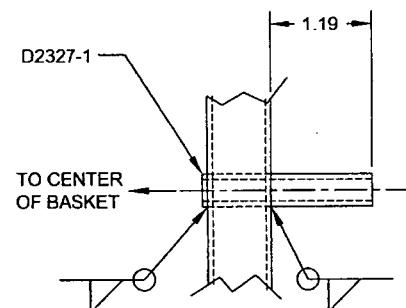


VIEW C-C SIMILAR BOTH END RIBS A5-2



SECTION D-D SAME BOTH CENTER RIBS A4-2

SHOP COPY  
RETURN TO  
ENGINEERING  
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WITHOUT NOTICE  
WORK ORDER  
NO. 53202



DETAIL E C6-4

**RELEASED**  
*08-06-17*

DESIGN	BW	DART AEROSPACE LTD
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO. REV. E
MFG. APPR.	<i>[Signature]</i>	D2512 SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE SCALE
DE APPR.	<i>[Signature]</i>	BASKET LID ASSEMBLY (350/212) NTS
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8 7 6 5 4 3 2 1